

1. (Amended) A method of extruding structural members comprising:

B<sub>1</sub> (a) providing an alloy comprising:  
about 3.6 to about 4.2 wt.% copper,  
about 1.0 to about 1.6 wt.% magnesium,  
about 0.3 to about 0.8 wt.% manganese,  
about 0.05 to about 0.25% zirconium,  
the balance substantially aluminum, incidental elements and impurities;

(b) homogenizing said alloy at a temperature between to a temperature between about 855° and 880°F prior to extruding said alloy at a temperature within about 500° to about 750°F to form an extrusion;

(c) solution heat treating said extrusion; and  
(d) quenching said extrusion before making a structural member therefrom.

B<sub>2</sub> 211 (New). A method of extruding structural members consisting essentially

of:

(a) providing an alloy comprising:  
about 3.6 to about 4.2 wt.% copper,  
about 1.0 to about 1.6 wt.% magnesium,  
about 0.3 to about 0.8 wt.% manganese,

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about 0.05 to about 0.25% zirconium,  
the balance substantially aluminum, incidental elements and  
impurities;

- (b) extruding said alloy at a temperature within about 500° to about 750°F to form an extrusion;
- (c) solution heat treating said extrusion;
- (d) quenching said extrusion before making a structural member therefrom; and
- (e) stretching said extrusion by at least about 1%.

12. (New) A method of extruding structural members having a combination of high strength and toughness, said method comprising:

- (a) providing an alloy comprising:
  - about 3.6 to about 4.2 wt.% copper,
  - about 1.0 to about 1.6 wt.% magnesium,
  - about 0.3 to about 0.8 wt.% manganese,
  - about 0.05 to about 0.25% zirconium,
  - the balance substantially aluminum, incidental elements and impurities;

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